

Work Order ID 51731



Page 1

August 31, 2009 2:22:51 PM

Item ID: D350-636-011

Accept



Setup Start



Revision ID: F

Stop



Item Name: Skidtube LH

Start Date: 08/31/2009 Start Qty: 1.00



Cust Item ID:

Required Date: 09/14/2009 Req'd Qty: 1.00



Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start



Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	----------------	--------------	--------------	---------------	---------------	------------------	----------------

Draw Nbr	Revision Nbr
D2750	Rev F

100

0.00



DOCUMENT CONTROL

DC

Memo

0.00

Document Control

Photocopy blue file and type labels per PPP D350-636-011 CHG 004

S 02/09/10

HJ for BG 09/09/10

Work Order ID 51731

August 31, 2009 2:22:51 PM



Page 2

Item ID: D350-636-011

Accept



Setup Start



Revision ID: F

Item Name: Skidtube LH

Stop



Start Date: 08/31/2009 Start Qty: 1.00



Cust Item ID:

Required Date: 09/14/2009 Req'd Qty: 1.00



Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start



Stop

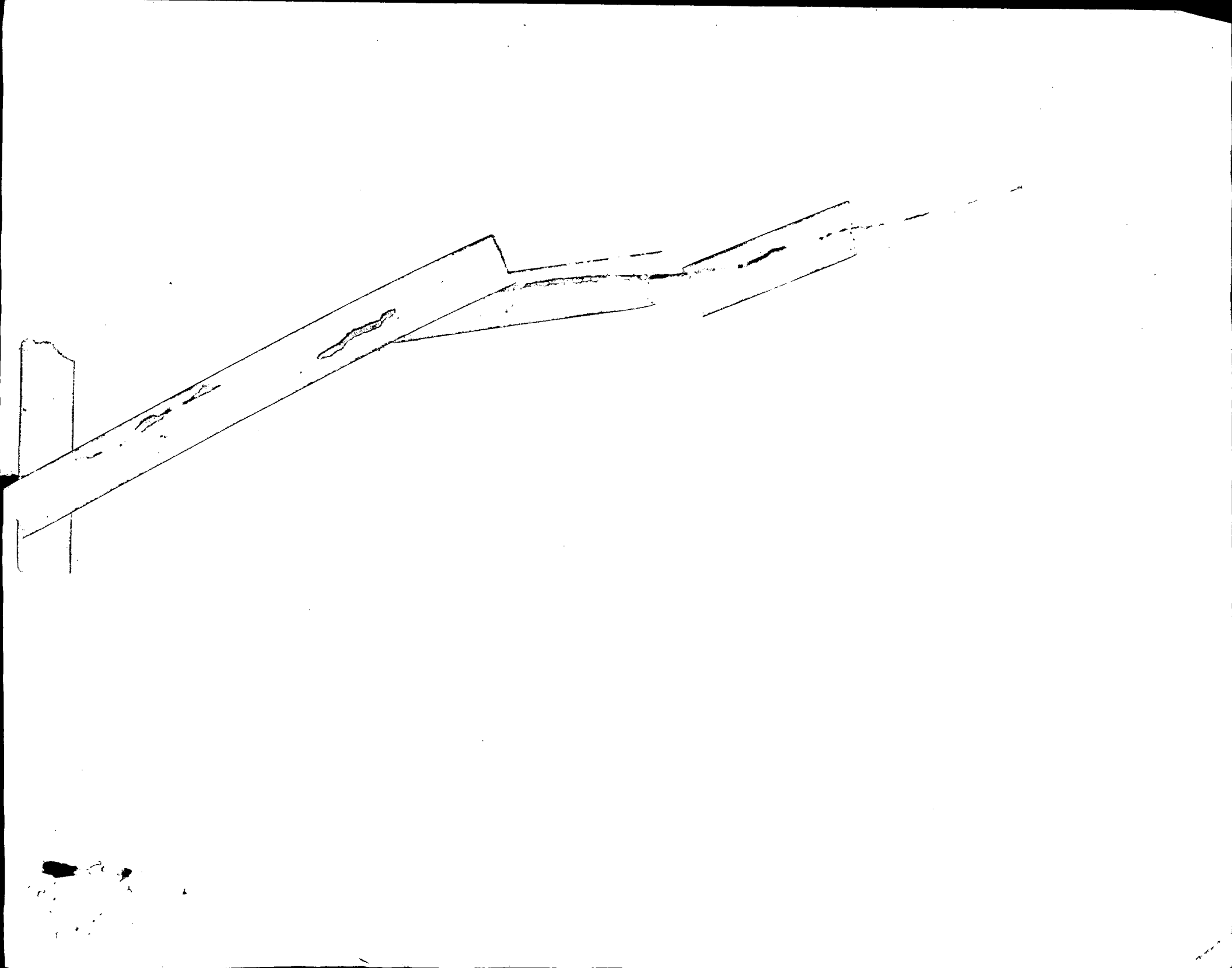


Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
110	Skidtubes	0.00							
Skidtubes	Memo	0.00							
Skidtubes	1- Mark cut line on aft end of D2600-3-Bent using Jig DT 8150. Cut to length as per Dwg D2750. Deburr end								
	2-Drill pilot holes as per Dwg D2750 sheet 4 (D2750-1 details).Drill using drill Jig DT8150 & DT8863.								
	3- Mark fwd end for cutting using Drill Jig DT 8150 & DT8863 and cut as per dwg D2750.								
	4- drill pilot holes for blade fitting bolt holes using DT8983. Open to 0.500"								
	5- locate DT8330 off of blade fitting bolt holes and drill pilot holes for blade fitting								
	6-Open up holes for Detail B to 0.375" (4 holes per side) and blade fitting location holes to 0.500" (total of 4 holes per side) as per dwg D2750 .Open up holes for ground handling and detail C to 0.500" (8 holes per side)								
	7-Drill pilot holes for wearplates as per Dwg D2750 using DT8108 open to 0.297".								
	8-Open up holes of Detail A to 0.297" (total of 2 holes per side)								
	9-Weld D2744 Cap as per Dwg D2750 and QSI 004.Fill grooves in bend left from bending as per QSI 004 A/R <input type="checkbox"/> Aluminum Rod <input checked="" type="checkbox"/> m111682								
	10-Grind welds flush as per Dwg D2750								

9-9-1

9-9-1

3 BE 9-9-2



Work Order ID 51731

August 31, 2009 2:22:51 PM



Page 3

Item ID: D350-636-011

Accept



Setup Start



Revision ID: F

Item Name: Skidtube LH

Stop



Start Date: 08/31/2009 Start Qty: 1.00



Cust Item ID:

Required Date: 09/14/2009 Req'd Qty: 1.00



Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
	12- Scribe batch# inside per dwg D2750								
120 QC Quality Control	QC10- Inspect visual per QSI004- ground welds Memo	0.00 0.00	⇒ S 08/02/09			(10)	φ		
130 QC Quality Control	QC5- Inspect part completeness to step on W/O Memo	0.00 0.00	⇒ S 08/02/09			(10)	φ		
140 HandFinish Hand Finishing	Chemical Conversion Coat per QSI005 4.1 Memo	0.00 0.00				(1X)	Q	MB 09-09-03	

Work Order ID 51731

August 31, 2009 2:22:51 PM



Page 5

Item ID: D350-636-011

Accept



Setup Start



Revision ID: F

Item Name: Skidtube LH

Stop



Start Date: 08/31/2009 Start Qty: 1.00



Cust Item ID:

Required Date: 09/14/2009 Req'd Qty: 1.00



Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run HoursDraw
NumberDraw
Rev.Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

160

0.00



Skidtubes

Skidtubes

Memo

0.00

Skidtubes

1-Open up holes of Detail C and ground handling to 0.625" (total of 8 holes per side)
as per dwg D2750.2-Open up holes of Detail B to 0.750" (total of 4 holes per side)
as per dwg D2750.

3- Open float hole to 0.500" (4 per side)

4-Chamfer holes of Detail B, C, ground handling and float holes per dwg D2750
(welding instructions on sheet 8)

5-Deburr and blow out all chips from inside of tube

6- Prepare tube for welding, remove alodine as required.

7-Bond web D2739 in place as per QSI 015

A/R ☐☐☐ Sikaflex-291batch: ☐☐☐

exp. date: 9-9-3

M112391 - AWM 9-9-3

8- Weld spacers D3490-1, D3490-3 and D2743 as per dwg D2750 & QSI004
(welding instructions on sheet 8)A/R ☐☐☐ Aluminum Rod

batch: M111682

BE 9-9-04

9-Grind welds flush as per Dwg D2750

10-Spot face ground handling holes section (total of 4 places per side) as per
dwg D2750

9-9-4

Work Order ID 51731

August 31, 2009 2:22:51 PM



Page 6

Item ID: D350-636-011

Accept



Setup Start



Revision ID: F

Stop



Item Name: Skidtube LH

Start Date: 08/31/2009 Start Qty: 1.00



Cust Item ID:

Required Date: 09/14/2009 Req'd Qty: 1.00



Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start



Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run HoursDraw
NumberDraw
Rev.Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

11-Deburr holes

DD 9-9-4

170



QC

Quality Control

QC10- Inspect visual per QSI004- ground welds

0.00

=> 5 09/09/09

Memo

0.00



/

180



QC

Quality Control

QC5- Inspect part completeness to step on W/O

0.00

=> 5 09/09/09

Memo

0.00



/

190



HandFinish

Hand Finishing

Pressure Wash per QSI005 4.3

0.00

6/2 09/09/08

D.

Memo

0.00

Work Order ID 51731

August 31, 2009 2:22:51 PM



Page 7

Item ID: D350-636-011

Accept



Setup Start



Revision ID: F

Stop



Item Name: Skidtube LH

Start Date: 08/31/2009 Start Qty: 1.00



Cust Item ID:

Required Date: 09/14/2009 Req'd Qty: 1.00



Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
200 Powdercoat Powder Coating	White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum Memo 11112260 START TIME: 11:15 AM OVEN TEMPERATURE: 320°F FINISH TIME: 11:45 AM	0.00 0.00	41	09/09/09		1	⊗		
210 QC Quality Control	QC3- Inspect Part Finish Memo BL 09-09-9 Inspect for foreign object per QSI 024	0.00 0.00		⓪.					
220 HandFinish Hand Finishing	HandFinishing Memo 1- Install inserts as per Dwg D2750	0.00 0.00		MD 09/09/09		ⓧ			

Work Order ID 51731

August 31, 2009 2:22:51 PM



Page 8

Item ID: D350-636-011

Accept



Setup Start



Revision ID: F

Stop



Item Name: Skidtube LH

Start Date: 08/31/2009 Start Qty: 1.00



Cust Item ID:

Required Date: 09/14/2009 Req'd Qty: 1.00



Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run HoursDraw
NumberDraw
Rev.Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

230

0.00



HandFinish

HandFinishing

Memo

0.00

1-Inspect for Foreign Objects

2-Spray inside of tube with "LPS-3"

batch: W/V

3-Install blade fitting D3488-041, wearshoes and ground handling hardware as per dwg D2750

SIKA FLEX 241

BATCH: m112391EXP DATE: 10/20

4-assemble o-ring to plug as per dwg D3492 and apply o-ring lube

A/R 55-o-ring lube batch: m101223

5-Coat all exposed fasteners with "LPS Procyon"

batch: m104251

(X1)

MO 09/09/09

240

QC5- Inspect part completeness to step on W/O

0.00



QC

Memo

0.00

⇒ 5 o-rings

(X1)

φ

Quality Control

Work Order ID 51731

August 31, 2009 2:22:51 PM

Page 9

Item ID: D350-636-011

Accept

Revision ID: F

Item Name: Skidtube LH

Setup Start

Stop

Start Date: 08/31/2009 Start Qty: 1.00

Required Date: 09/14/2009 Req'd Qty: 1.00

Cust Item ID:

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start

Stop

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
250 Pick Kit		0.00							
Packaging	Memo	0.00							PC4/9/10 (U)
Packaging									
260 QC	QC4- 100% Inspect kits for completeness	0.00							
Quality Control	Memo *****ensure antiseize is on AN8C21A bolts*****	0.00							(X) p
270 Packaging		0.00							
Packaging	Memo	0.00							Rev G 9/9/10 Q54
Packaging	Package as per PPP D350-636-011								

51731

Work Order ID 51731

August 31, 2009 2:22:51 PM



Page 10

Item ID: D350-636-011

Accept



Setup Start



Revision ID: F

Stop



Item Name: Skidtube LH

Start Date: 08/31/2009 Start Qty: 1.00



Cust Item ID:

Required Date: 09/14/2009 Req'd Qty: 1.00



Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run HoursDraw
NumberDraw
Rev.Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

280

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

09/09/10 *[Signature]*
MF
09-09-10

Picklist Print

August 31, 2009 2:22:51 PM

Page 1

Work Order ID: 51731

Parent Item: D350-636-011RevF

Parent Item Name: Skidtube LH

Start Date: 08/31/2009

Required Date: 09/14/2009

Comments:

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
D2744RevC		Manufactured	No			110	Each	54.0000	1.0000			
Cap												

Warehouse
Location

Loc Qty

Loc Code

Main Warehouse

ST

54

44892

19

47488

35

1 BE 9-9-2

D2600-3-BENTRevD1

Manufactured

No

110

Each

0.0000

1.0000

Extrusion Bent

D2743RevB

Manufactured

No

160

Each

294.0000

8.0000

Crossbolt Spacer

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

LG

50

50281

50

Main Warehouse

ST

244

44891

2

45555

177

48275

65

8 BE 9-9-4

Picklist Print

August 31, 2009 2:22:51 PM

Page 2

Work Order ID: 51731

Parent Item: D350-636-011RevF

Parent Item Name: Skidtube LH


Comments:

Start Date: 08/31/2009

Required Date: 09/14/2009

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
D2739RevD  350 I Beam		Manufactured	No			160	Each	6.0000	1.0000			

Warehouse Loc Qty Loc Code

Location

Main Warehouse

LG

4

50353

4

Main Warehouse

ST

2

47124

1

47681

1

1 B47681, AWM 9.9-3

D3490-3RevA

Manufactured No

160

Each

112.0000

4.0000



Cross Bolt Spacer

Warehouse Loc Qty Loc Code

Location

Main Warehouse

ST

112

45560

22

47471

35

48276

55

A 4 BE 9.9-4

August 31, 2009 2:22:51 PM

Shop Packet Print

Page 2

Picklist Print

August 31, 2009 2:22:51 PM

Work Order ID: 51731

Parent Item: D350-636-011RevF

Parent Item Name: Skidtube LH


Start Date: 08/31/2009

Required Date: 09/14/2009

Comments:

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
D3490-1RevA  Cross Bolt Spacer		Manufactured	No			160	Each	165.0000	4.0000			

Warehouse Loc Qty Loc Code

Location

Main Warehouse

ST	165	
45338	2	
47118	4	
47657	50	
48277	109	

ALS4-1032-225

Purchased

No

220

Each

8,822.000

38.0000

Insert

Warehouse Loc Qty Loc Code

Location

Main Warehouse

ST	8822	
107441	16	
110768	8806	

D3492-041RevC

Manufactured

No

230

Each

3.0000

8.0000

Plug Assembly

Warehouse Loc Qty Loc Code

Location

Main Warehouse

ST	3	
43816	3	

August 31, 2009 2:22:51 PM

Shop Packet Print

Picklist Print

August 31, 2009 2:22:51 PM

Work Order ID: 51731

Parent Item: D350-636-011RevF

Parent Item Name: Skidtube LH

Comments:

Start Date: 08/31/2009

Required Date: 09/14/2009

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	--------------------------	---------------	----------------	--------

D3793-3RevA

Manufactured

No

230

Each

22.0000

1.0000



Wearshoe

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST

22

47720
50246

11
11

XI

MD 09/09/09

AN8C35A

Purchased

No

230

Each

167.0000

1.0000



BOLT

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST

167

102180

1

106896

1

110105

65

110847

100

XI

MO 09/09/09

Picklist Print

August 31, 2009 2:22:51 PM

Work Order ID: 51731

Parent Item: D350-636-011RevF

Parent Item Name: Skidtube LH



Comments:

Start Date: 08/31/2009

Required Date: 09/14/2009

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
D3793-1RevA  Wearshoe		Manufactured	No			230	Each	18.0000	1.0000 			

<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
<u>Location</u>		
Main Warehouse		
ST	18	
40551	1	
47537	4	
50231	13	

X1 MW 09/09/09

D3488-041RevB  Blade Fitting Assembly, LH		Manufactured	No			230	Each	29.0000	1.0000 			
--	--	--------------	----	--	--	-----	------	---------	---	--	--	--

<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
<u>Location</u>		
Main Warehouse		
ST	29	
41853	1	
44530	8	
47348	20	

X1 MW 09/09/09

Picklist Print

August 31, 2009 2:22:51 PM

Work Order ID: 51731

Parent Item: D350-636-011RevF

Parent Item Name: Skidtube LH



Comments:

Start Date: 08/31/2009

Required Date: 09/14/2009

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
D3794-3RevA 		Manufactured	No			230	Each	27.0000	1.0000			
Gasket												

Warehouse Loc Qty Loc Code

Location

Main Warehouse

ST 27

46531 2

47440 2

47722 11

50240 12

X1 mo 09/09/09

AN6C44A



BOLT

Purchased

No

230

Each

172.0000

4.0000



Warehouse Loc Qty Loc Code

Location

OFFSHORE

FG 2

103964 2

Main Warehouse

ST 170

110105 4

110155 14

110665 1

110865 51

111605 50

111649 50

X4 mo 09/09/09

Picklist Print

Page 7

August 31, 2009 2:22:51 PM

Work Order ID: 51731



Parent Item: D350-636-011RevF



Parent Item Name: Skidtube LH

Start Date: 08/31/2009

Required Date: 09/14/2009

Comments:

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
MS21083C8 		Purchased	No			230	Each	92.0000	1.0000			
NUT												

<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
<u>Location</u>		
Main Warehouse		
ST	92	
110584	5	
111424	2	
111637	21	
112243	44	
112492	20	

21 MD 09/09/09

D3536-25RevA

Manufactured No



230

Each

21.0000

1.0000



<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
<u>Location</u>		
Main Warehouse		
ST	21	
45569	1	
47011	2	
47526	8	
50266	10	

21 MD 09/09/09

Picklist Print

Page 8

August 31, 2009 2:22:51 PM

Work Order ID: 51731

Parent Item: D350-636-011RevF

Parent Item Name: Skidtube LH


Comments:

Start Date: 08/31/2009

Required Date: 09/14/2009

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
D3631-1RevA  Washer		Manufactured	No			230	Each	105.0000	8.0000			

Warehouse Loc Qty Loc Code

Location

Main Warehouse

ST

105

38139

6

45353

16

47437

83

D3791-1RevA



Wearplate

Manufactured No

230

Each

18.0000

1.0000

X8 mp 09/09/09

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST

18

47536

8

50269

10

X1 mp 09/09/09

August 31, 2009 2:22:51 PM

Shop Packet Print

Page 8

Picklist Print

Page 9

August 31, 2009 2:22:51 PM

Work Order ID: 51731



Parent Item: D350-636-011RevF



Parent Item Name: Skidtube LH



Start Date: 08/31/2009

Required Date: 09/14/2009

Comments:

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
AN960C10L  washer		Purchased	No			230	Each	2,846.000	38.0000			
												

Warehouse

Loc Qty

Loc Code

Location

OFFSHORE

FG

100

103585

100

Main Warehouse

ST

2746

112116

2746

V38 MD 09/09/09

August 31, 2009 2:22:51 PM

Shop Packet Print

Page 9

Picklist Print

August 31, 2009 2:22:51 PM

Work Order ID: 51731

Parent Item: D350-636-011RevF

Parent Item Name: Skidtube LH


Comments:

Start Date: 08/31/2009

Required Date: 09/14/2009

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
D2745RevB  Bushing		Manufactured	No			230	Each	272.0000	8.0000			

Warehouse Loc Qty Loc Code

Location

Main Warehouse

ST	272
34817	2
36230	8
37303	1
39587	2
40726	2
41114	2
42778	19
43754	2
44893	37
45556	69
46695	18
48278	110

X8 MO 09/09/09

AN3C5A



Bolt

Purchased

No

230

Each

650.0000

34.0000

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST	650
111424	8
111707	342
112314	200
112489	100

X84 MO 09/09/09

August 31, 2009 2:22:51 PM

Shop Packet Print

Picklist Print

Page 11

August 31, 2009 2:22:51 PM

Work Order ID: 51731

Parent Item: D350-636-011RevF

Parent Item Name: Skidtube LH


Start Date: 08/31/2009

Required Date: 09/14/2009

Comments:

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
D3537-1RevC  Wearpad		Manufactured	No			230	Each	46.0000	3.0000			

Warehouse Loc Qty Loc Code

Location

Main Warehouse

FP

46

48288

3

50321

43

AN960C816L

Purchased

No

230

Each

330.0000

1.0000



WASHER

Warehouse Loc Qty Loc Code

Location

Main Warehouse

ST

330

104093

2

107520

4

110139

29

110372

36

110584

100

111424

159

D3492-043RevC

Manufactured

No

230

Each

0.0000

8.0000



Plug Assembly

46407

48273

x 3

x 5

MO 09/09/09

August 31, 2009 2:22:51 PM

Shop Packet Print

Page 11

Picklist Print

Page 12

August 31, 2009 2:22:51 PM

Work Order ID: 51731

Parent Item: D350-636-011RevF

Parent Item Name: Skidtube LH


Comments:

Start Date: 08/31/2009

Required Date: 09/14/2009

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
AN3C6A  BOLT		Purchased	No			230	Each	1,060.000	4.0000			

Warehouse Loc Qty Loc Code

Location

Main Warehouse

ST

1060

110372

84

111982

976

X4 MD 09/09/09

NAS1611-013

Purchased

No

230

Each

320.0000

1.0000

O-RING

Warehouse Loc Qty Loc Code

Location

Main Warehouse

ST

320

106513

11

111424

109

111758

200

X8 MD 09/09/09

NAS1611-010

Purchased

No

230

Each

345.0000

1.0000

O-RING

Warehouse Loc Qty Loc Code

Location

Main Warehouse

ST

345

110715

50

110915

295

P10

August 31, 2009 2:22:51 PM

Shop Packet Print

Page 12

W/O: 51731		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
09/09/09	#230	Replaced O-Ring NAS1611-010 By O-ring DAS94-3 Batch#: 29908 (X8)	mo	09/09/09	8		S 09/09/09

Part No: D350-636-011 PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

August 31, 2009 2:22:51 PM

Work Order ID: 51731

Parent Item: D350-636-011RevF

Parent Item Name: Skidtube LH


Comments:

Start Date: 08/31/2009

Required Date: 09/14/2009

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
D3535-25RevB  Wearshoe		Manufactured	No			230	Each	11.0000	1.0000			

Warehouse Loc Qty Loc Code

Location

Main Warehouse

ST

11

47523

11

D3794-1RevA

Manufactured

No

230

Each

7.0000

1.0000



Gasket

Warehouse Loc Qty Loc Code

Location

Main Warehouse

ST

7

46530

1

47212

2

47721

4

MS21043-6

Purchased

No

230

Each

1,132.000

4.0000



NUT

Warehouse Loc Qty Loc Code

Location

Main Warehouse

ST

1132

110584

34

111424

98

112314

1000

X1 MD 09/09/09

X1 MD 09/09/09

X4 MD 09/09/09

Picklist Print

Page 14

August 31, 2009 2:22:51 PM

Work Order ID: 51731

Parent Item: D350-636-011RevF

Parent Item Name: Skidtube LH

Comments:

Start Date: 08/31/2009

Required Date: 09/14/2009

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	--------------------------	---------------	----------------	--------

D3493-1RevA

Manufactured

No

260

Each

115.0000

2.0000

✓



Washer



09/01/10 ①

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST

115

44902

15

47710

100

44902

MS21083C8

Purchased

No

260

Each

92.0000

2.0000

✓



NUT



09/01/10 ①

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST

92

110584

5

111424

2

111637

21

112243

44

112492

20

11/22/03

11/29

August 31, 2009 2:22:51 PM

Shop Packet Print

Page 14

Picklist Print

August 31, 2009 2:22:51 PM

Work Order ID: 51731

Parent Item: D350-636-011RevF

Parent Item Name: Skidtube LH


Comments:

Start Date: 08/31/2009

Required Date: 09/14/2009

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
AN8C21A  BOLT		Purchased	No			260	Each	112.0000	2.0000			

8/9/10

Warehouse
Location

Loc Qty

Loc Code

Main Warehouse

ST

112

105160

1

107596

1

107924

2

109092

2

110341

2

110342

4

111605

50

111684

50

M111684

AN960C816L

Purchased

No

260

Each

330.0000

2.0000



WASHER

8/9/10

Warehouse
Location

Loc Qty

Loc Code

Main Warehouse

ST

330

104093

2

107520

4

110139

29

110372

36

110584

100

111424

159

M111424

Picklist Print

Page 16

August 31, 2009 2:22:51 PM

Work Order ID: 51731

Parent Item: D350-636-011RevF

Parent Item Name: Skidtube LH


Comments:

Start Date: 08/31/2009

Required Date: 09/14/2009

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
NAS1515H3L  WASHER		Purchased	No			260 230	Each	350.0000	4.0000			

Warehouse Loc Qty Loc Code

Location

OFFSHORE

FG

40

102472

40

Main Warehouse

ST

310

110450

2

110806

8

111819

300

D2741RevC

Manufactured No

260

Each

40.0000

1.0000



Blade, 350 Skidtube

Warehouse Loc Qty Loc Code

Location

Main Warehouse

ST

40

20770

0

45320

1

47113

39

210

MO 09/09/09

09/10/09

24

47113

August 31, 2009 2:22:51 PM

Shop Packet Print

Page 16

W/O: 51731		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
09/09/09	#260	Route seq ID 260 for NASISISH3L should be Route seq ID 230	MD CE	09/09/09 09.09.10			S 09/09/10

Part No: D350-636-011 PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

Page 17

August 31, 2009 2:22:51 PM

Work Order ID: 51731

Parent Item: D350-636-011RevF

Parent Item Name: Skidtube LH

Start Date: 08/31/2009

Required Date: 09/14/2009

Comments:

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	--------------------------	---------------	----------------	--------

D3532-1RevA

Manufactured

No

260

Each

43.0000

2.0000 ✓



Spacer

09/8/10 (1)

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST

43

38161

2

44904

41

NAS1515H8L

Purchased

No

260

Each

129.0000

2.0000 ✓



WASHER

44904

09/8/10 (1)

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST

129

107581

34

108964

1

111650

94

11/16/09

August 31, 2009 2:22:51 PM

Shop Packet Print

Page 17

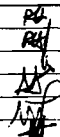
QTY -041	QTY -042	QTY -043	QTY -044	PART NUMBER	DESCRIPTION
X				D2750-041	350 SKIDTUBE ASSEMBLY, LH
	X			D2750-042	350 SKIDTUBE ASSEMBLY, RH
		X		D2750-043	350 SKIDTUBE ASSEMBLY, LH
			X	D2750-044	350 SKIDTUBE ASSEMBLY, RH
1	1	1	1	D2739	WEB
8	8	8	8	D2743	SPACER
1	1	1	1	D2744	CAP
8	8	8	8	D2745	BUSHING
1				D2750-1	SKIDTUBE WELDMENT, LH
	1			D2750-2	SKIDTUBE WELDMENT, RH
		1		D2750-3	SKIDTUBE WELDMENT, LH
			1	D2750-4	SKIDTUBE WELDMENT, RH
1		1		D3488-041	BLADE FITTING, LH
	1		1	D3488-042	BLADE FITTING, RH
4	4	4	4	D3490-1	SPACER
4	4			D3490-3	SPACER
		4	4	D3490-5	SPACER
8	8	8	8	D3492-041	PLUG ASSEMBLY
8	8			D3492-043	PLUG ASSEMBLY
		8	8	D3492-045	PLUG ASSEMBLY
1	1	1	1	D3535-25	WEARSHOE
1	1	1	1	D3536-25	GASKET
3	3	3	3	D3537-1	WEARPAD
8	8	8	8	D3631-1	WASHER
1	1	1	1	D3791-1	WEARPLATE
1	1	1	1	D3793-1	WEARSHOE
1	1	1	1	D3793-3	WEARSHOE
1	1	1	1	D3794-1	GASKET
1	1	1	1	D3794-3	GASKET
38	38	38	38	ALS4-1032-225	INSERT (OR ALS7-1032-225, AKS4-1032-225, AELS-1032-225)
34	34	34	34	AN3C5A	BOLT
4	4	4	4	AN3C6A	BOLT
4	4	4	4	AN6C44A	BOLT
1	1	1	1	AN8C35A	BOLT
38	38	38	38	AN960C10L	WASHER
1	1	1	1	AN960C816L	WASHER
4	4	4	4	MS21043-6	NUT
1	1	1	1	MS21083C8	NUT
4	4	4	4	NAS1515H3L	WASHER

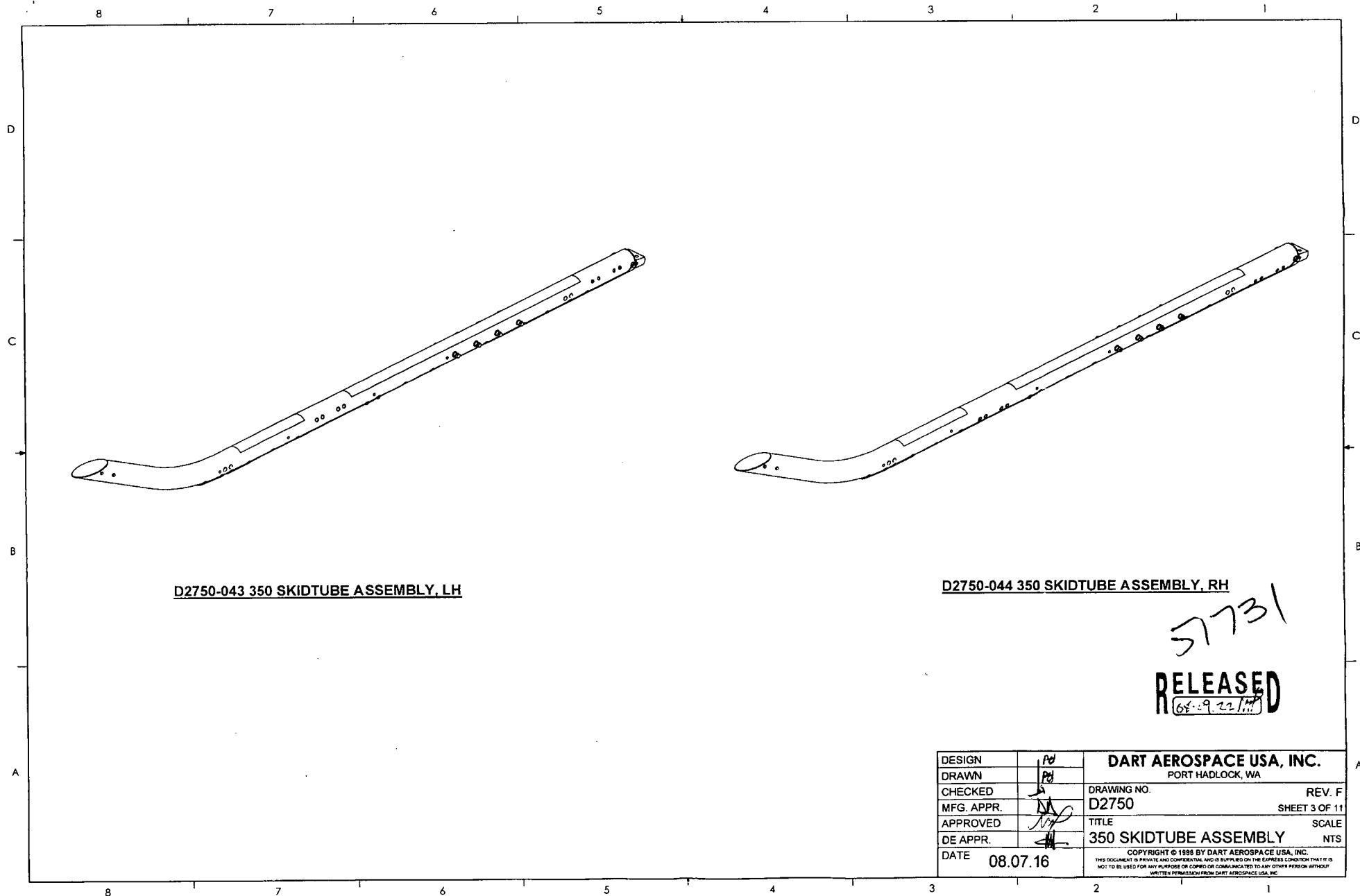
GENERAL NOTES:

- 1) MATERIAL: MAKE D2750-1/-2/-3/-4 FROM D2600-3 EXTRUSION (INITIAL LENGTH = 120.0).
- 2) FINISH: ACID ETCH, ALONDE ASSEMBLY PER DART QSI 005 4.1 PRIOR TO INSTALLING D2739 WEB. POWDER COAT WHITE (REF. 4.3.5.1) PER DART QSI 005 4.3. BLACK ANTI-SKID PAINT AS INDICATED TO 1.0 ABOVE SKIDTUBE CENTER-LINE PER DART 005 4.4 (OPTIONAL).
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: D2750-041/-042/-043/-044 = 26.5 LBS
- 8) WELD PER DART QSI 004
- 9) INSTALL ALS4-1032-225 INSERTS AFTER FINISH AS INDICATED. DRILL 'F' SIZE HOLES ($\phi 0.297$) FOR WEARSHOE INSERTS
- 10) FINAL CONFIGURATION SHOULD HAVE THE FOLLOWING MINIMUM MECHANICAL PROPERTIES:
MINIMUM YIELD TENSILE STRENGTH = 35 KSI
MINIMUM ULTIMATE TENSILE STRENGTH = 38 KSI
- 11) SPRAY INSIDE OF TUBE WITH A COAT OF LPS LABORATORIES "LPS-3" AFTER FINISH AND AFTER INSTALLATION OF INSERTS. COAT ALL EXPOSED FASTENERS WITH LPS LABORATORIES "LPS PROCYON" AFTER FINAL ASSEMBLY, CLEAN EXCESS OFF POWDER COATING WITH MEK DEGREASER.
- 12) SPACER AND PLUG INSTALLED SAME AS SECTION AJ-AJ EXCEPT HORIZONTAL
- 13) SPACER AND PLUG INSTALLED SAME AS SECTION AP-AP EXCEPT HORIZONTAL

451731
mf
09-08-31

RELEASED
68-07-22

F	INCORPORATE DSI 9413; QTY (3) D3537-1 WAS QTY (5) (ZN C8-1); D3791-1/-3 REPLACES D3535-13/-35 (ZN C8-1); D3794-1/-3 REPLACES D3536-13/-35 (ZN B8-1); ADD D3791-1 (ZN C8-1); WEARSHOE HOLES UNDER FWD/AFT SADDLE REMOVED (8 PL). WEARSHOE HARDWARE QTY UPDATED (ZN B8-1); D3488-041/-042 HARDWARE UPDATED (ZN C1-8, 9, 10, 11); ADD NOTE 12 AND 13 (ZN A6-1); REASON: REF. NCR 08-043	PH	08.07.16
E	CHANGE TO STAINLESS STEEL WEARPLATES; ADD RUBBER GASKETS, CHANGE INSERTS; ADD D3631-1; REMOVE QTY (38) NAS1515H3L; REMOVE QTY (10) NAS1515H8L; REMOVE D2741; QTY (2) AN960C816; REMOVE QTY (2) MS21083C8	CB	07.05.17
D	ADD HOLES AND SPACERS FOR APICAL FLOATS; INCORPORATE DEO 9133/9157	PH	06.01.05
C	ADD D2750-3/D2750-4; INCORPORATE D2738 AND D2740	CP	98.11.18
B	CHANGE MS24694-S293 TO AN8-16A	CP	98.09.01
A	NEW ISSUE	DS	98.04.16
REV.	DESCRIPTION	BY	DATE
DESIGN	 DRAWING NO. D2750 TITLE 350 SKIDTUBE ASSEMBLY	DART AEROSPACE USA, INC. PORT HADLOCK, WA	
DRAWN			
CHECKED			
MFG. APPR.			
APPROVED			
DE APPR.			
DATE		08.07.16	
COPYRIGHT © 1988 BY DART AEROSPACE USA, INC. THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSES OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.			

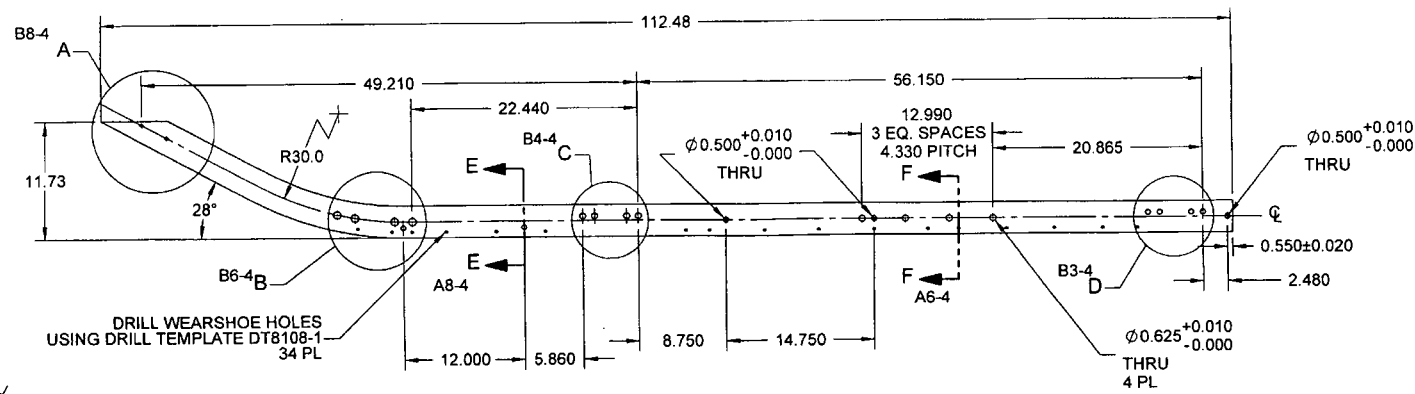


D2750-043 350 SKIDTUBE ASSEMBLY, LH

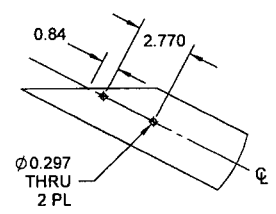
D2750-044 350 SKIDTUBE ASSEMBLY, RH

57731
RELEASED
 68-9-22/111

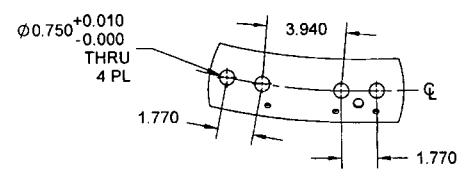
DESIGN	PH	DART AEROSPACE USA, INC.	
DRAWN	PH	PORT HADLOCK, WA	
CHECKED	PH	DRAWING NO.	REV. F
MFG. APPR.	PH	D2750	SHEET 3 OF 11
APPROVED	PH	TITLE	SCALE
DE APPR.	PH	350 SKIDTUBE ASSEMBLY	NTS
DATE	08.07.16	<small>COPYRIGHT © 1988 BY DART AEROSPACE USA, INC. THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COMMERCE OR TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.</small>	



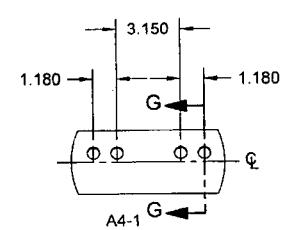
D2750-1 LH SKIDTUBE



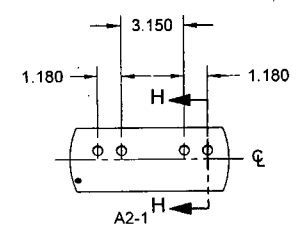
DETAIL A
SCALE 2X



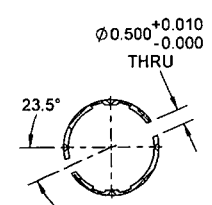
DETAIL B
SCALE 2X



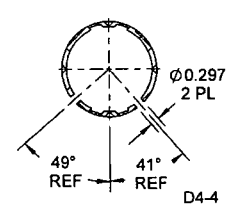
DETAIL C
SCALE 2X



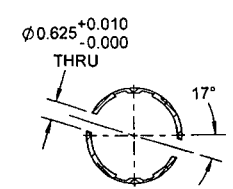
DETAIL D
SCALE 2X



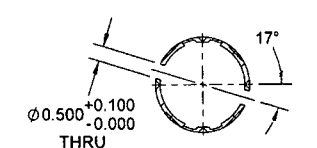
SECTION E-E
SCALE 3X, 2 PL



SECTION F-F
SCALE 3X, 17 PL



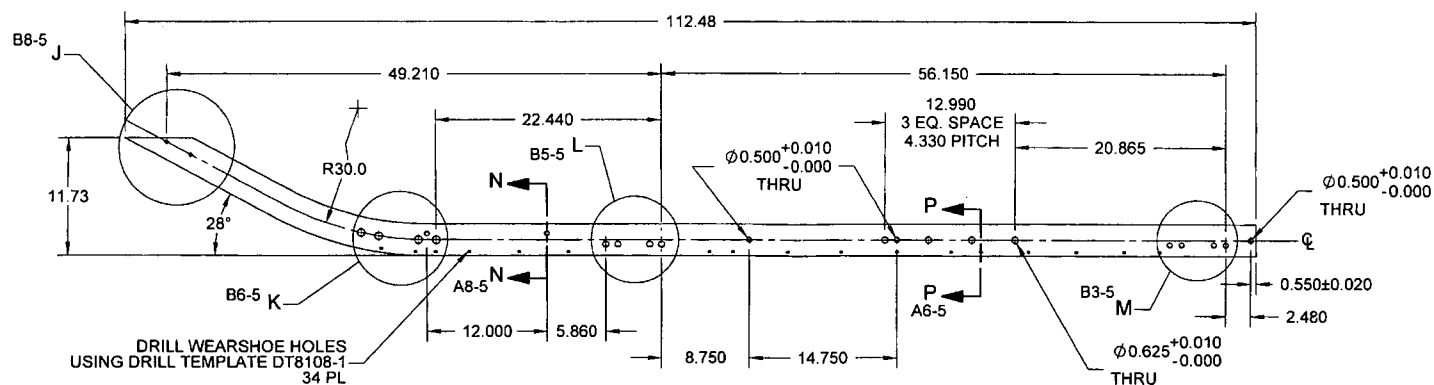
SECTION G-G
SCALE 3X, 4 PL



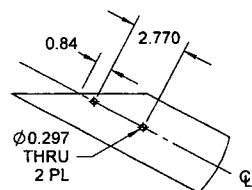
SECTION H-H
SCALE 3X, 4 PL

51731
RELEASED

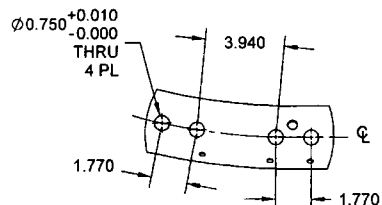
DESIGN	PM	DART AEROSPACE USA, INC.	
DRAWN	PM	PORT HADLOCK, WA	
CHECKED		DRAWING NO.	REV. F
MFG. APPR.		D2750	SHEET 4 OF 11
APPROVED		TITLE	SCALE
DE APPR.		350 SKIDTUBE ASSEMBLY	NTS
DATE	08.07.16	<small>COPYRIGHT © 1998 BY DART AEROSPACE USA, INC. THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.</small>	



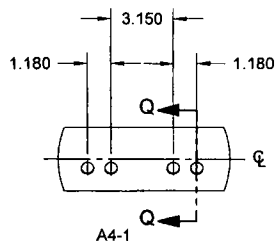
D2750-2 RH SKIDTUBE



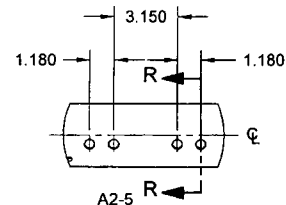
DETAIL J
SCALE 2X



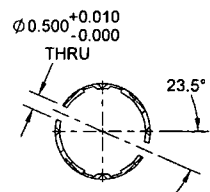
DETAIL K
SCALE 2X



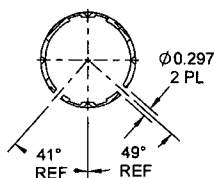
DETAIL L
SCALE 2X



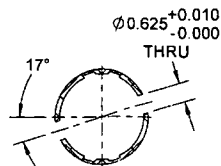
DETAIL M
SCALE 2X



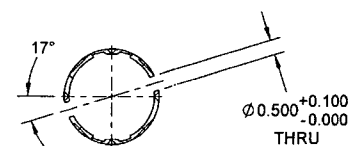
SECTION N-N
SCALE 3X, 2 PL



SECTION P-P
SCALE 3X, 17 PL



SECTION Q-Q
SCALE 3X, 4 PL



SECTION R-R
SCALE 3X, 4 PL

DESIGN	REV	DART AEROSPACE USA, INC.	
DRAWN	REV	PORT HADLOCK, WA	
CHECKED		DRAWING NO.	REV. F
MFG. APPR.		D2750	SHEET 5 OF 11
APPROVED		TITLE	SCALE
DE APPR.		350 SKIDTUBE ASSEMBLY	NTS
DATE	08.07.16	COPYRIGHT © 1998 BY DART AEROSPACE USA, INC.	
		THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.	

51731
RELEASED

8

7

6

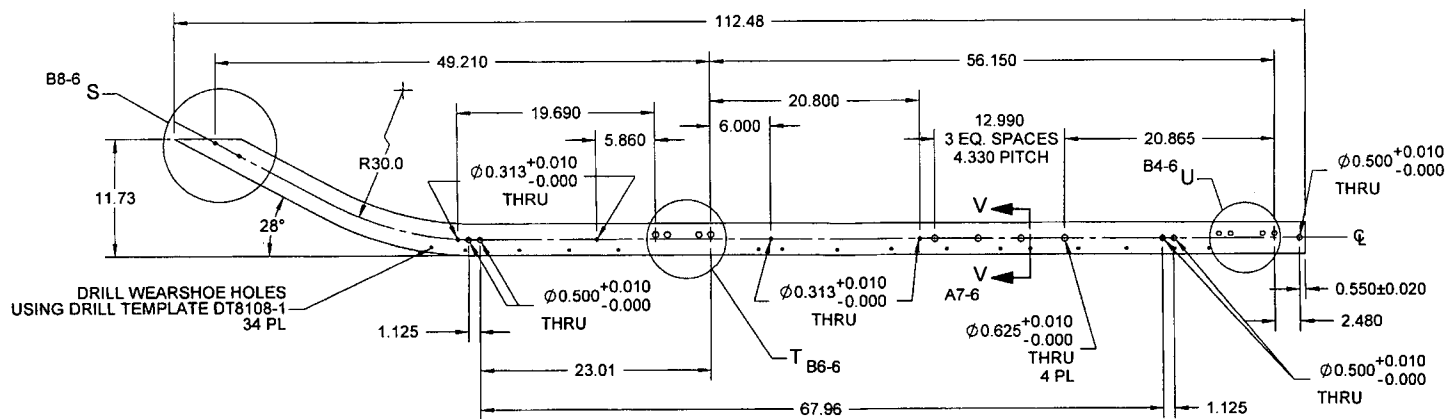
5

4

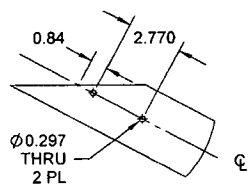
3

2

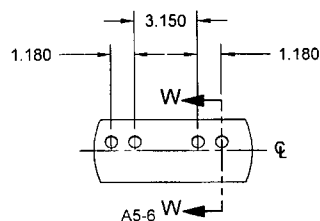
1



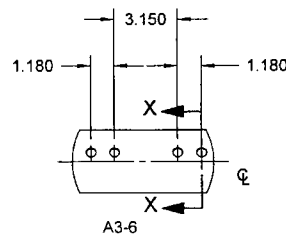
D2750-3 LH SKIDTUBE



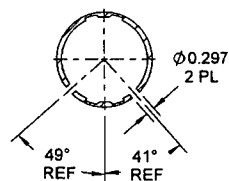
DETAIL S
SCALE 2X



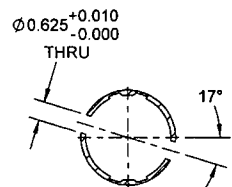
DETAIL T
SCALE 2X



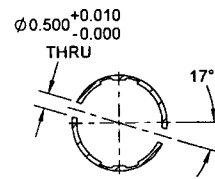
DETAIL U
SCALE 2X



SECTION V-V
SCALE 3X, 17 PL




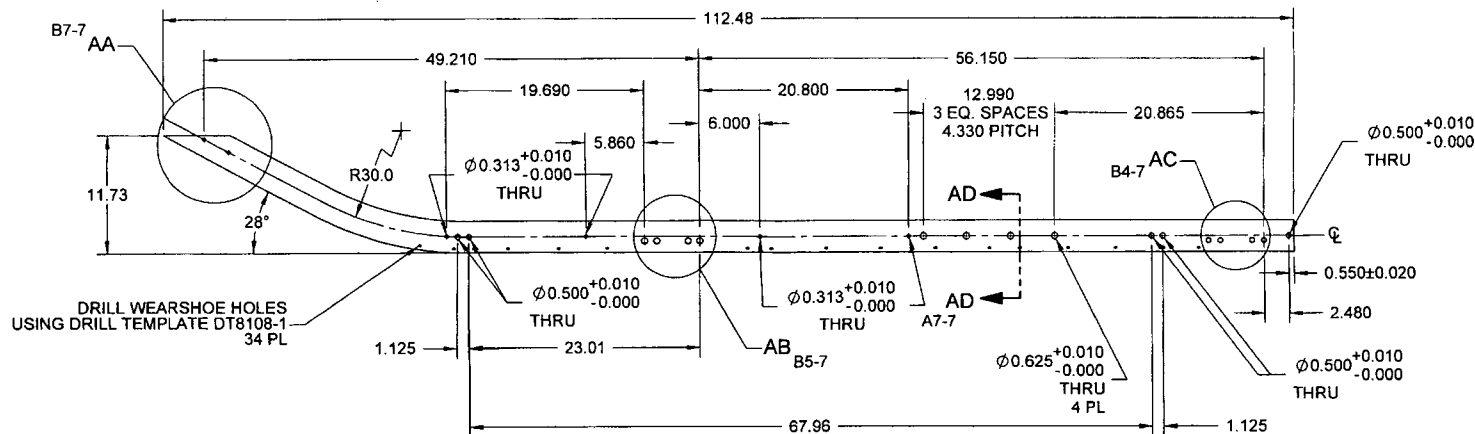
SECTION W-W
SCALE 3X, 4 PL



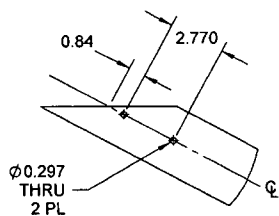
SECTION X-X
SCALE 3X, 4 PL

51731
RELEASED

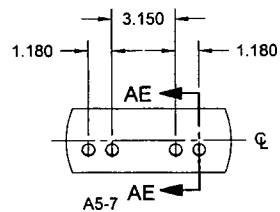
DESIGN		DART AEROSPACE USA, INC.	
DRAWN		PORT HADLOCK, WA	
CHECKED		DRAWING NO.	REV. F
MFG. APPR.		D2750	SHEET 6 OF 11
APPROVED		TITLE	SCALE
DE APPR.		350 SKIDTUBE ASSEMBLY	NTS
DATE	08.07.16	<small>COPYRIGHT © 1998 BY DART AEROSPACE USA, INC. THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.</small>	



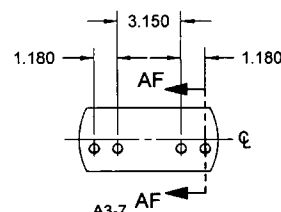
D2750-4 RH SKIDTUBE



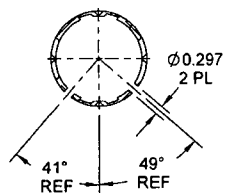
DETAIL AA
SCALE 2X



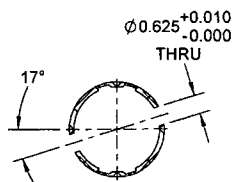
DETAIL AB
SCALE 2X



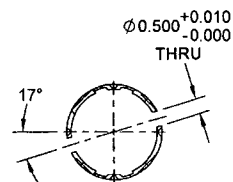
DETAIL AC
SCALE 2X



SECTION AD-AD
SCALE 3X, 17 PL



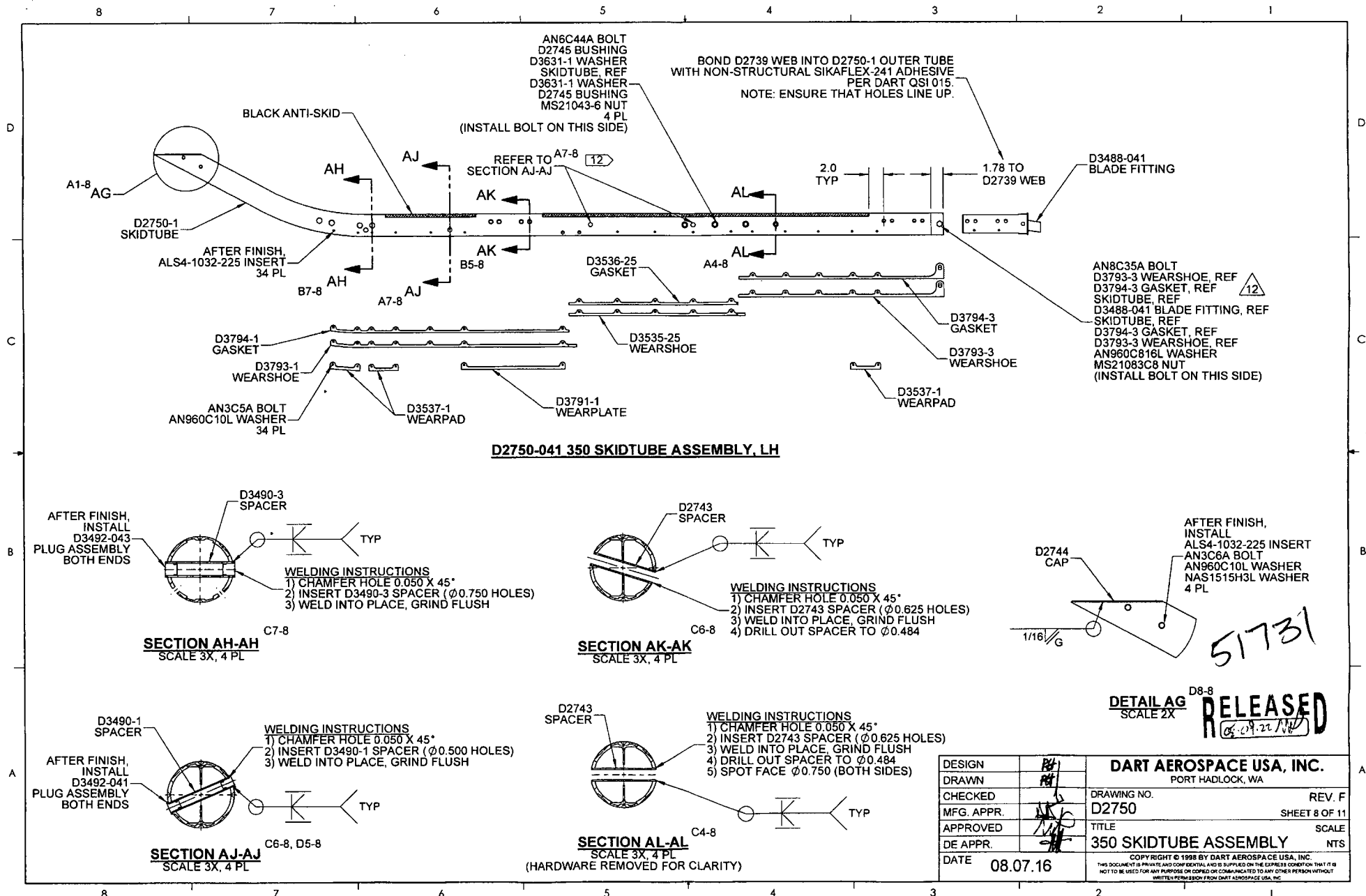
SECTION AE-AE
SCALE 3X, 4 PL

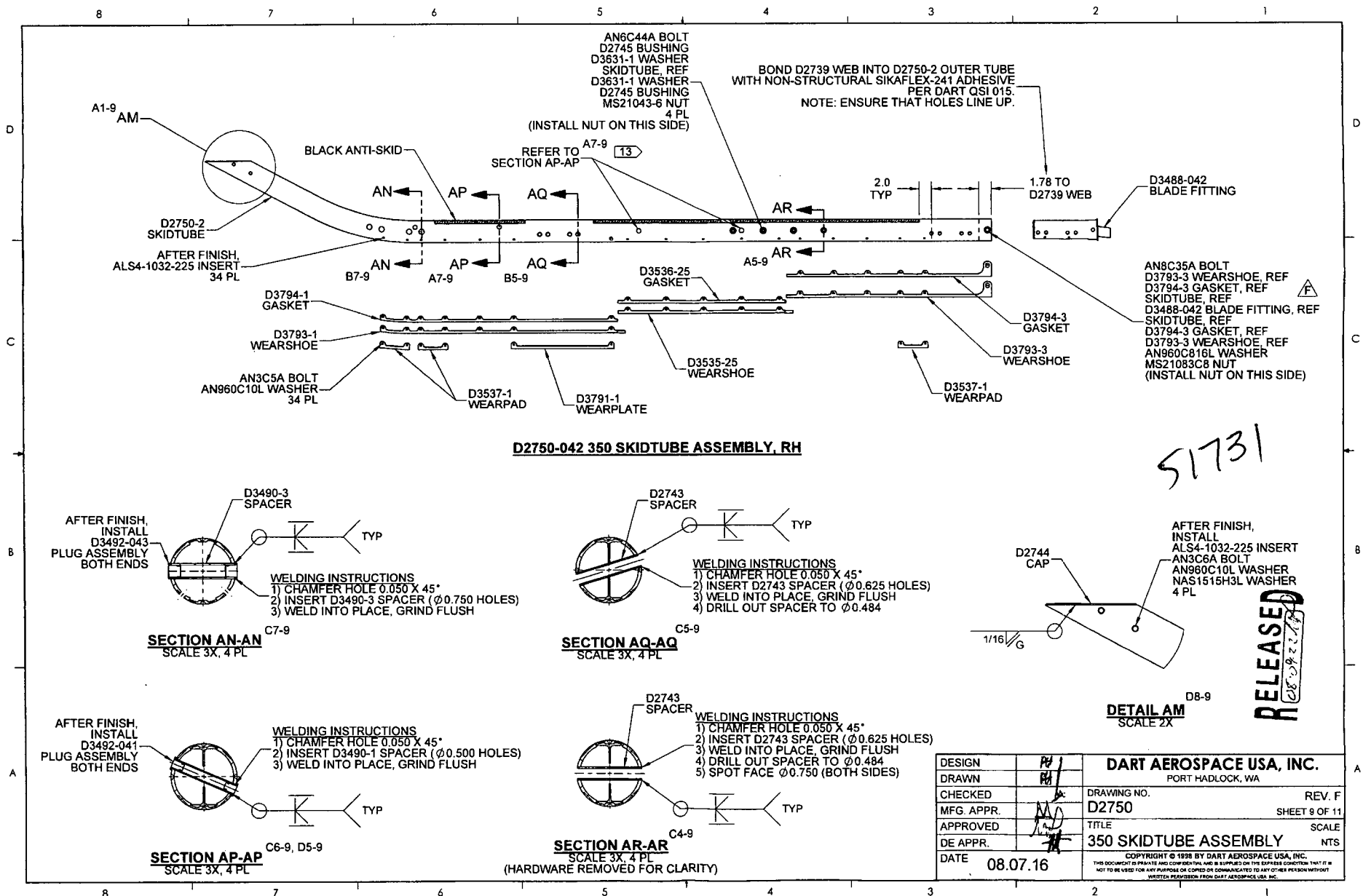


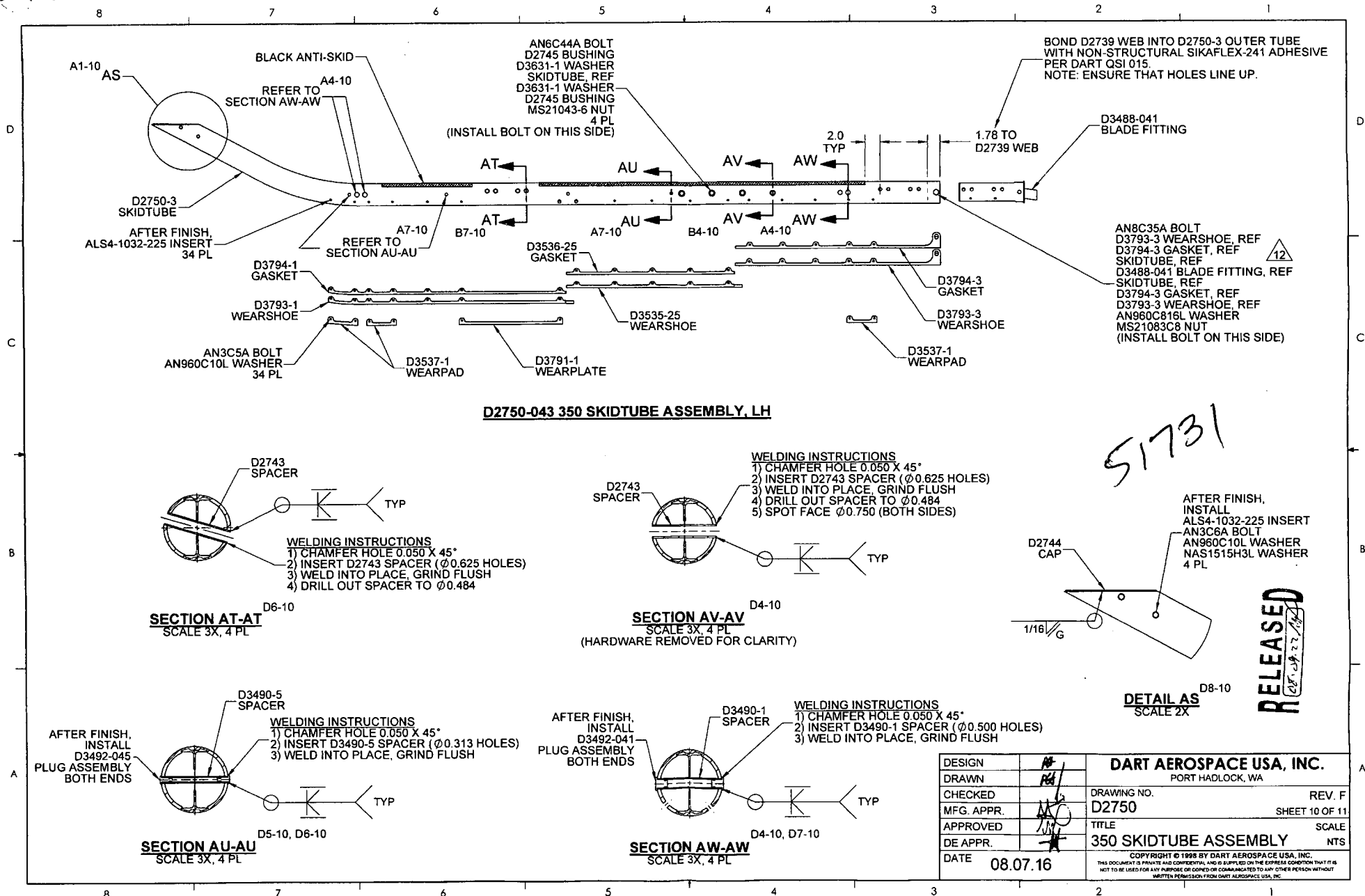
SECTION AF-AF
SCALE 3X, 4 PL

51731
RELEASED
08-04-2016

DESIGN	PA	DART AEROSPACE USA, INC.	
DRAWN	PA	PORT HADLOCK, WA	
CHECKED	PA	DRAWING NO.	REV. F
MFG. APPR.	PA	D2750	SHEET 7 OF 11
APPROVED	PA	TITLE	SCALE
DE APPR.	PA	350 SKIDTUBE ASSEMBLY	NTS
DATE	08.07.16	COPYRIGHT © 1998 BY DART AEROSPACE USA, INC. THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.	







REFERENCE ONLY

6.0 PARTS LIST

(D350-636-011/-012/-013/-014 SKIDTUBES AT CHANGE 004 OR LATER)

Item	Qty -011	Qty -012	Qty -013	Qty -014	Qty -045	Part Number	Description
	X					D350-636-011	SKIDTUBE INSTALLATION, LH, STD AERAZUR/APICAL CYLINDRICAL FLOAT COMPATIBLE
		X				D350-636-012	SKIDTUBE INSTALLATION, RH, STD AERAZUR/APICAL CYLINDRICAL FLOAT COMPATIBLE
			X			D350-636-013	SKIDTUBE INSTALLATION, LH AIRCRAUSER/ APICAL TRI-BAG FLOAT COMPATIBLE
				X		D350-636-014	SKIDTUBE INSTALLATION, RH AIRCRAUSER/ APICAL TRI-BAG FLOAT COMPATIBLE
					X	D350-636-045	WEARSHOE KIT
1	1					D2750-041	SKIDTUBE ASSEMBLY, LH
1		1				D2750-042	SKIDTUBE ASSEMBLY, RH
1			1			D2750-043	SKIDTUBE ASSEMBLY, LH
1				1		D2750-044	SKIDTUBE ASSEMBLY, RH
*1	1					D2750-1	SKIDTUBE WELDMENT, LH
*1		1				D2750-2	SKIDTUBE WELDMENT, RH
*1			1			D2750-3	SKIDTUBE WELDMENT, LH
*1				1		D2750-4	SKIDTUBE WELDMENT, RH
**2	8	8	8	8		350A41-1027-20	SCREW
**3	8	8	8	8		23119AG120LE	WASHER
**4	8	8	8	8		22541N120	NUT
*5	1	1	1	1		AN8C35A	BOLT
*6A	1	1	1	1		AN960C816L	WASHER
*7	1	1	1	1		MS21083C8	NUT
*8	1		1			D3488-041	BLADE FITTING, LH
*8		1		1		D3488-042	BLADE FITTING, RH
9	1	1	1	1		D2741	BLADE
10	2	2	2	2		AN8C21A	BOLT
11A	2	2	2	2		AN960C816L	WASHER
11B	2	2	2	2		NAS1515H8L	WASHER
12	2	2	2	2		MS21083C8	NUT
*14	4	4	4	4		AN6C44A	BOLT
*15	8	8	8	8		D2745	BUSHING
*16	4	4	4	4		MS21043-6	NUT
*17	8	8	8	8		D3631-1	WASHER
*18	4	4	4	4		ALS4-1032-225	INSERT
*19	4	4	4	4		AN3C6A	BOLT
*20A	4	4	4	4		AN960C10L	WASHER
*20B	4	4	4	4		NAS1515H3L	WASHER

(CONTINUED ON NEXT PAGE)

51731

(CONTINUED FROM PREVIOUS PAGE)

Item	Qty -011	Qty -012	Qty -013	Qty -014	Qty -045	Part Number	Description
*22	3	3	3	3	3	D3537-1	WEARPAD
*22A	1	1	1	1	1	D3791-1	WEARPLATE (REPLACES D3537-1)
*23A	1	1	1	1	1	D3793-1	WEARSHOE (REPLACES D3535-13)
*23B	1	1	1	1	1	D3794-1	GASKET (REPLACES D3536-13)
*24A	1	1	1	1	1	D3535-25	WEARSHOE
*24B	1	1	1	1	1	D3536-25	GASKET
*25A	1	1	1	1	1	D3793-3	WEARSHOE (REPLACES D3535-35)
*25B	1	1	1	1	1	D3794-3	GASKET (REPLACES D3536-35)
*26A	34	34	34	34	34	AN3C5A	BOLT
*27	34	34	34	34	34	AN960C10L	WASHER
*28	34	34	34	34		ALS4-1032-225	INSERT
*30	8	8	8	8		D3492-041	PLUG ASSEMBLY
*31	8	8				D3492-043	PLUG ASSEMBLY
*32			8	8		D3492-045	PLUG ASSEMBLY
***43	2	2	2	2		D3493-1	WASHER
50	2	2				D3532-1	SPACER

* PART OF D2750-041/-042 OR D2750-043/-044 ASSEMBLY

** TO BE SUPPLIED BY CUSTOMER

*** ONLY INSTALLED IF INSTALLING AN APICAL FLOAT SYSTEM

5/1/93

• COPYRIGHT © 1998 BY DART AEROSPACE USA, INC. •

THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.

Revision: F
Date: 08.08.14

NO. 203

AWS D17.1.2001
QUALIFICATION TEST RECORD

Name: Barday Elliott
Job number: 5011
Part number: D350 636 014
Description: 350 skid tube
Welding Process: Tig[☒] Mig[]
Base material: Aluminium
Current: AC[☒] DC[]

TEST REQUIREMENTS AND RESULTS

Visual: pass[☒] fail[]
Penetration: pass[☒] fail[]

UNACCEPTABLE

Cracks: pass[☒] fail[]
Undercut: pass[☒] fail[]
Pin holes: pass[☒] fail[]
Overlap (cold lap): pass[☒] fail[]
Porosity (surface): pass[☒] fail[]
Coloration: pass[☒] fail[]

Qualifier P. D. Del Date of Test Coupon 09-07-14
Welder Barday Elliott Date of Test Coupon 09-07-14

The above named individual is qualified in accordance with AWS D17.1.2001 to weld